

Date: Wednesday, 18/06/2008 11:20:29 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206 A/B STEP ASSEMBLY RH
Job Number	: 39911		
Estimate Number	: 11115		
P.O. Number	:	Part Number	: D206628012
This Issue	: 18/06/2008 S.O. No. :	Drawing Number	: N/A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : LARGE FAB ASSY	Drawing Revision	: N/A
Previous Run	: 37737	Material	:
Written By	:	Due Date	: 05/07/2008 Qty: 4 Um: Each
Checked & Approved By	: <u>JLD 08.6.18</u>		
Comment	: Est Rev:D As Per Ecn 766 06-01-06 JLM est rev E changed D2731-1 to D2731-3 EC Est Rev:F as per ecn 1118 08-02-05 DD verified by:		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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JLD 08.6.18



Comment: DOCUMENT CONTROL.

Photocopy blue file and type labels as per PPP D206-628-012 CHG 003

S 08/7/29

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0	39911A	206B STEP ASSY, RH
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Comment: Sub-Component 206B STEP ASSY, RH

1 x D2721-042 Batch 39911A

4.0	D2732030	Rubber Cushion
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Comment: Qty.: 8.0000 Each(s)/Unit

Total : 32.0000 Each(s)

8x3 = 24 + 12 = 2x4 = 8 P1120

Rubber Cushion

batch 37632

5.0	AN413A	Bolt
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Bolt

batch M168700 10x M167955 6K

R 8/7/29 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 A/B STEP ASSEMBLY RH

Job Number: 39911

Part Number: D206628012

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

AN414A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Bolt

batch M107537

7.0

D27313

Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch
2 D2731-3 Mounting Lug 37335

8.0

D27317

Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch
2 D2731-7 Mounting Lug 37336

9.0

D3394041

Lug Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch
2 D3394-041 LUG ASS,Y 37345

10.0

D3394043

Lug Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch
2 D3394-043 LUG ASS,Y 34834

11.0

AN415A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description Batch
4 AN4-15A Bolt M107737 4x M108077 12x

18/07/09 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Date: Wednesday, 18/06/2008 11:20:29 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 A/B STEP ASSEMBLY RH

Job Number: 39911

Part Number: D206628012

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

AN960JD416

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

12 AN960JD416

Washer

M1=7939

13.0

MS21042L4

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

12 MS21042L4

Nut (or MS21042-4)

M1=7478

14.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-628-012

Location:

PPP Rev:

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-07-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 18/06/2008 11:20:36 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206B STEP ASSY, RH
Job Number	: 39911A		
Estimate Number	: 11699		
P.O. Number	:	Part Number	: D2721042
This Issue	: 18/06/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D2721 REV C
First Issue	: / /	Project Number	: N/A
Previous Run	: 37737A	Drawing Revision	: C
Written By	:	Material	:
Checked & Approved By	: <u>JUL 08-6-18</u>	Due Date	: 05/07/2008
Comment	: Est Rev:F As Per Ecn 766 06-01-06 JLM	Qty:	4 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2622120C	Step Extrusion
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)
 Qty Part # Description Batch:
 1 D2622-120C Extrusion B 37754 (3)
 B 39316 (1)

Check Material for any Dents or Defects

SAN 08/06/18 (7)

2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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**Comment:** LARGE FABRICATION RESOURCE 1

Cut D2721-2 using D2622 extrusion as per Dwg D2721
 Deburr and bevel ends for welding

SAN 08/06/18 (4)

3.0	D2734	Step End Plate
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)
 206 Step Endplate

Pick:

Qty	Part Number	Description	Batch
2	D2734	End Cap	B 36520

4. 4.
 1/2 SP 08-07-23
 1/2 SP 08-07-08

4.0	D34611	Mounting Plate
-----	--------	----------------

**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

206 Step Lug

Pick:

Qty	Part Number	Description	Batch
1	D3461-1	Plate	B 33070

08-07-09 SP

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 18/06/2008 11:20:36 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B STEP ASSY, RH

Job Number: 39911A

Part Number: D2721042

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	D34613	Mounting Plate
-----	--------	----------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description
1	D3461-3	Plate

Batch

B33071 4X

08-07-08

✓
PK
SP

6.0	D34615	Mounting Plate
-----	--------	----------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description
1	D3461-5	Plate

Batch

B33862 4X

08-07-08

✓
PK
SP

7.0	D34617	Mounting Plate
-----	--------	----------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description
1	D3461-7	Plate

Batch

B33863 4X

08-07-08

✓
PK
SP

8.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

Weld end cap (One End Only) and lugs as per Dwg D2721 using Jig DT followed by Jig DT

A/R AL Rod

Batch:

M1106838
M107678

4X

Grind end cap welds flush

08-07-08

08-07-09

SP.
PK
SP

9.0	QC9	VISUAL WELDING INSPECTION
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Comment: VISUAL WELDING INSPECTION

PD 08-07-16

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2721-042 PAR #: N/A Fault Category: Prod / FAB Large NCR: (Yes) No DQA: [Signature] Date: 08/08/16
 QA: N/C Closed: [Signature] Date: 08/08/16

NCR: 39911A		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/07/16	8.0	During Q9 welding inspection it was noticed that the welding on the D3461-1-3-5-2 3 rd step out of 5. Pin holes in the weld RC. Dnt in weld.	[Signature]	Grind out Pin holes in weld in affected area. Re weld AS per Q51004 OK # <u>11106834</u>	[Signature] 08-01-16 [Signature] 08-01-16	[Signature] 08/07/16	[Signature] 08/07/16	[Signature] 08/07/16
			[Signature]	Ensure welded area is clean before welding.			[Signature]	[Signature] 08/07/16

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B STEP ASSY, RH

Job Number: 39911A

Part Number: D2721042

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/07/16 (4) RH

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

215 08/07/17 (4)

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BL 08-07-17 (4) RH

13.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Inspect for foreign object per QSI 024

Weld Remaining end cap as per Dwg D2721 using Jig DT

followed by Jig DT

A/R AL Rod

Batch:

H106834

Grind End Cap Welds Flush

→ SAD 08/07/24 (4) 08-07-24 SP/KE

14.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-07-24 (4)

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/07/24 (4) RH

16.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch Up Alodine

FL 08/07/24 (4)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B STEP ASSY, RH

Job Number: 39911A

Part Number: D2721042

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

POWDER COATING

POWDER COATING



M 108523



(4X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

12:50
320°C
1:20

M-F 08/07/28

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(4)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BF 08-07-28

19.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



M 108496



(4)

Comment: Wing Walk as per Dwg D2721 and QSI 005 4.4

BF 08-07-28

20.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(4X)
50

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8/7/29

21.0

PACKAGING 1

PACKAGING RESOURCE #1



SP
4X

Comment: PACKAGING RESOURCE #1

Identify and Check

Location:

39911

8/7/29

22.0

QC21

FINAL INSPECTION/W/O RELEASE



08/08/01

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



M-F 08-07-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED
05-11-14

APPLY BLACK
ANTI-SKID ON
- TOP SURFACE
TO BOTTOM
OF TOP RADIUS

— REFER TO STEP
END DETAIL

D2721-1
MAKE FROM EXTRUSION D2622-078

D2721-041 LH STEP ASSEMBLY (SHOWN)
D2721-042 RH STEP ASSEMBLY (OPPOSITE)

ROUND CORNER OF EXTRUSION TO
MATCH BEND RADIUS OF END PLATE

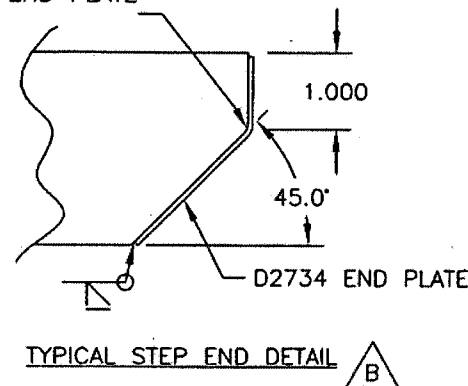
D2721-041/-042 STEP ASSEMBLY PARTS LIST

QTY - 041	QTY - 042	PART NUMBER	DESCRIPTION
X		D2721-041	LH STEP ASSEMBLY
	X	D2721-042	RH STEP ASSEMBLY
1	1	D2622-078	EXTRUSION
2	2	D2734	END PLATE
1	1	D3461-1	PLATE
1	1	D3461-3	PLATE
1	1	D3461-5	PLATE
1	1	D3461-7	PLATE

D2721-041/-042 STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
2) WELD PER DART QSI 004
3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
4) ALL DIMENSIONS ARE IN INCHES
5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 35417



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